

Work Order ID 150146

Tuesday, December 06, 2016 9:29:51 AM

150146

Page 1

Item ID: D4034-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Upper Rib Assembly
Start Date: 8/22/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/24/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: DAS 21 DEC 06 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4034	C								
100	Weld per dwg A/R S.S. rod Batch: <u>134102</u>	0.00							
100									
Large Fab	Memo	0.44							
Large Fab	1- Assemble ribs to hoop and weld as per dwg DT9564								
	2- Weld bushing in rib and grind weld flush as per dwg								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.01							
Quality Control									

4 C 16-12-064x DAS 43 9-89 DEC 09 20164x DAS 43 9-89 DEC 09 2016

Work Order ID 150146***150146***

Page 2

Tuesday, December 06, 2016 9:29:51 AM

Item ID: D4034-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Upper Rib Assembly

Start Date: 8/22/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: WWA 04

0.00

130

Packaging

Memo

0.01

Packaging

LOCATION: WA004

4xDAS
43
9-89

DEC 09 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.07

Quality Control

DAS
21
9-89

DEC 12 2016

DAS
21
9-89

DEC 09 2016

Picklist Print

Tuesday, December 06, 2016 9:29:57 AM

Page 1

Work Order ID: 150146

150146

Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 8/22/2016

Required Date: 8/24/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER
DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER DWG
REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD
VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4034-1 Rib		Manufactured	No			100	Each	16.0000	1	4			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA004			16					
					152155			12					
					152156			4					
✓ D4034-3 Rib		Manufactured	No			100	Each	5.0000	1	4			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA004			5					
					150385			5					
✓ D4021-7 Hoop		Manufactured	No			100	Each	6.0000	1	4			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA004			6					
					151757			2					
					153507			4					

**

4 C/P 16-12-06

**

4 C/P 16-12-06

**

B151099 4 C/P 16-12-06

Picklist Print

Tuesday, December 06, 2016 9:29:57 AM

Page 2

Work Order ID: 150146

150146

Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 8/22/2016

Required Date: 8/24/2016

Start Qty: 4.00

Required Qty: 4.00

D4021-9

Manufactured

No

100

Each

188.0000

4

16

✓ ***D4021-9***
Bushing

16 C 16-12-06

Location

Loc Qty

Loc Code

WA004

188

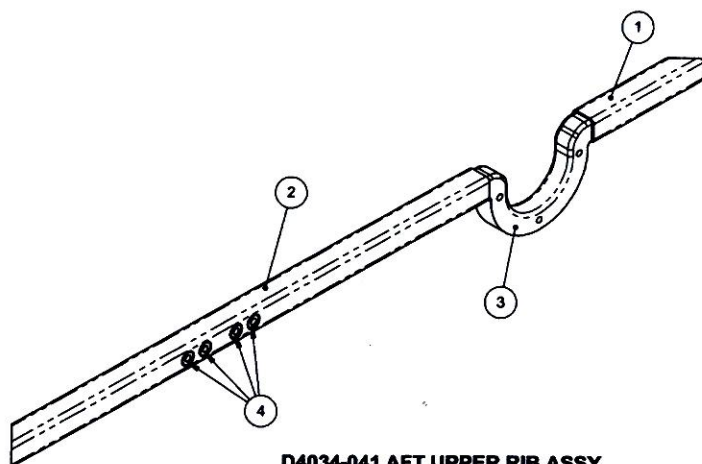
145800

2

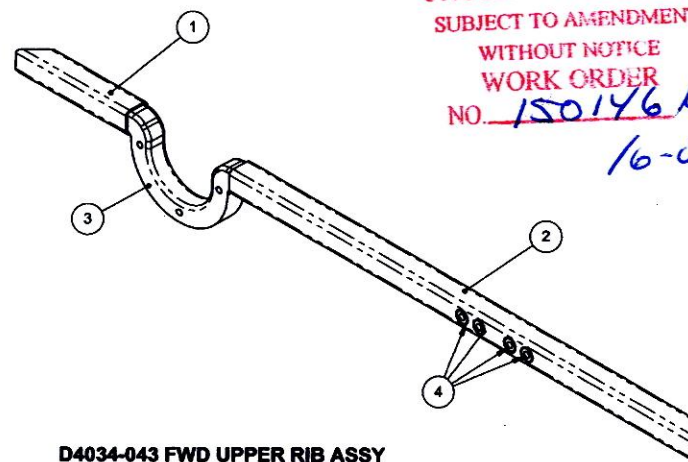
152261

186

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1	1	D4034-3	RIB
3	1	1	D4021-7	HOOP
4	4	4	D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY

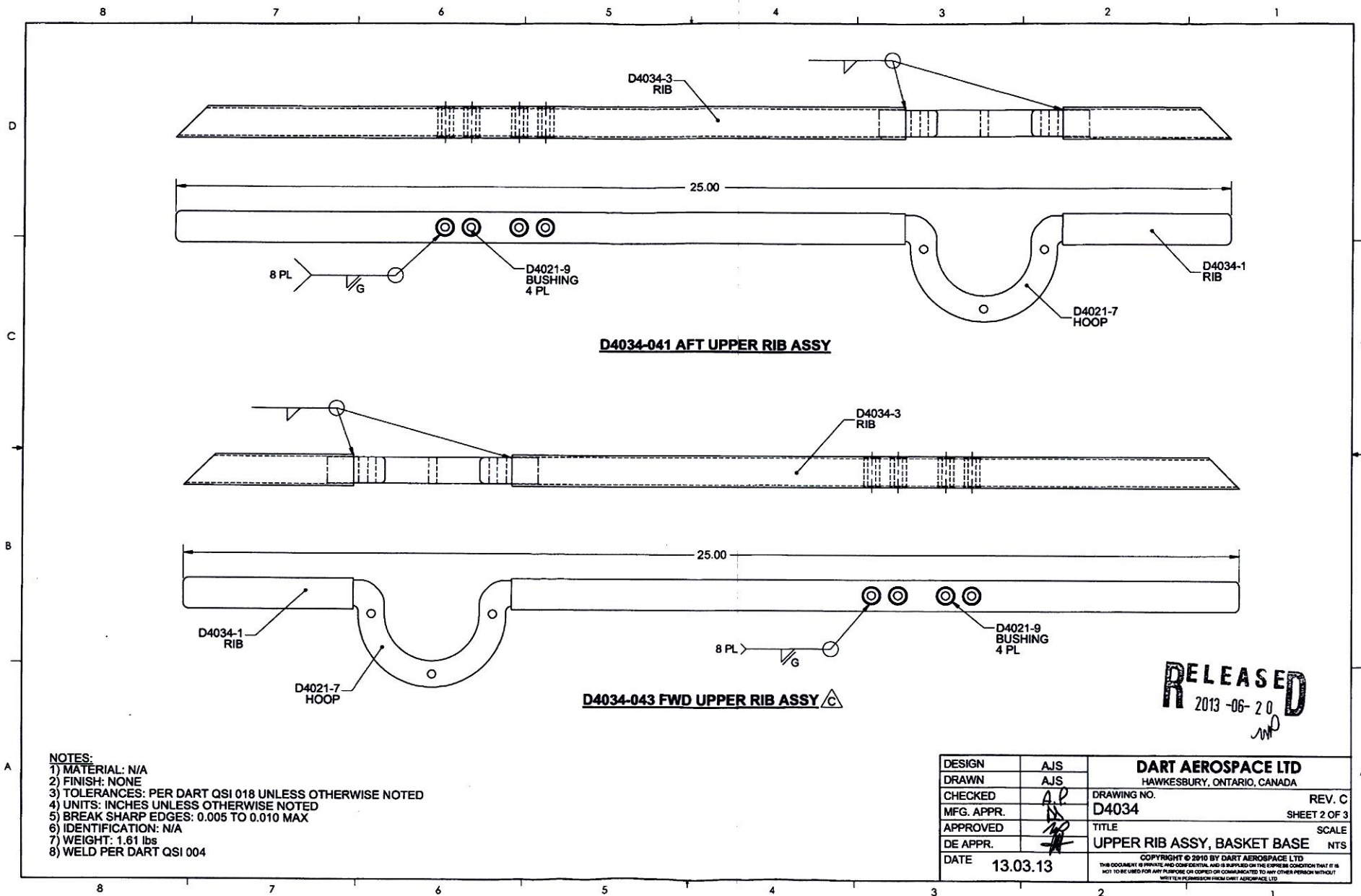


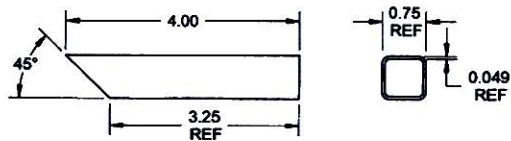
D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150146 MJS
16-08-24

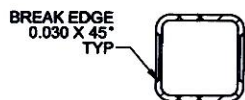
RELEASED
2013-06-20
AM

C	-043 REDESIGNED AS MIRROR IMAGE OF -041 -5 DELETED. D2327-3 DELETED. REASON PROP ARM NO LONGER OFFERED.		AJS	13.03.13
B	ADDITIONAL HOLES ADDED ON D4034-3 RIB		SC	10.12.20
A	NEW ISSUE		AJS	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4034 TITLE UPPER RIB ASSY, BASKET BASE	REV. C	SHEET 1 OF 3
DRAWN	AJS		SCALE	NTS
CHECKED	A.P.			
MFG. APPR.	AS			
APPROVED	AP			
DE APPR.	—			
DATE	13.03.13		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

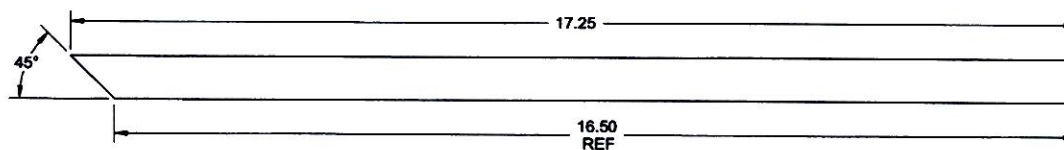
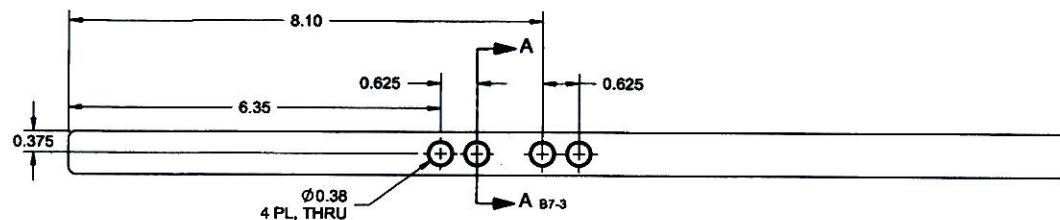




D4034-1 RIB



SECTION A-A C3-3



D4034-3 RIB

RELEASED
2013-06-28

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO. D4034	REV. C SHEET 3 OF 3
MFG. APPR.	DS	TITLE	SCALE
APPROVED	AP	UPPER RIB ASSY, BASKET BASE	NTS
DE APPR.	AP	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	13.03.13	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	